

# PATENT ABSTRACTS OF JAPAN

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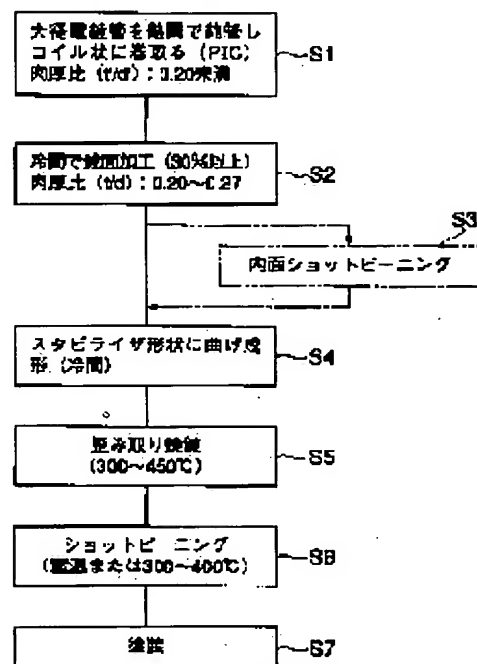
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## (54) MANUFACTURE OF HOLLOW STABILIZER

### (57)Abstract:

**PROBLEM TO BE SOLVED:** To satisfy a sufficiently lighter weight and durability by cold drawing a raw tube so as to have a specified area reduction ratio or more to provide a thick pipe material having a thickness ratio within a specified range larger than an electro-resistance-welded steel tube and a specified tensile strength, and cold bending it into a stabilizer shape.

**SOLUTION:** An electro-resistance-welded steel tube of major diameter is hot contracted to provide a lengthy raw tube (S1). In cold drawing process, the area reduction ratio is increased to 30% or more, and the thickness ratio (t/D) to 0.20-0.27 to provide a thick pipe material having a tensile strength of 800-1000 N/mm<sup>2</sup> (S2). Inner surface shot peening is performed as occasion demands, and the thick pipe material is cold bent by use of a forming machine and molded into a desired stabilizer shape (S3, S4). It is heated to about 300-450° C by an oven to remove the toxic residual stress (S5). Thereafter, shot peening and rust preventing painting are performed (S6, S7). According to this, a lighter weight and durability can be satisfied.



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### LEGAL STATUS

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